

Work Order ID 63998

Tuesday, November 23, 2010 9:26:06 AM



Page 1

Item ID:	D2230-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Lug				Stop	
Start Date:	11/22/2010	Start Qty:	80.00			
Required Date:	11/30/2010	Req'd Qty:	80.00			
Reference:						

Approvals:	Process Plan:		Date:	12/1-23	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2230	Rev G

100		BAND SAW	0.00						
	Bandsaw	Memo	0.00						
	Jeaspa Bandsaw	Cut D2423 extrusion to 0.82"							
		Batch:							

at @ meter

110		HAAS CNC VERTICAL MACHINING #1	0.00						
	HAAS 1	Memo	0.00						
	HAAS CNC vertical machine #1	1-Machine per folio FA927							
		DWG REV:							
		FOLIO REV:							
		(Check for crack while loading into the machine.)							
		2- deburr rough edges							

710 13003

CY 10/11/25 80

issue 710 to meter
machine per dwg D2230 REV.G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63998

Tuesday, November 23, 2010 9:26:06 AM



Page 2

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 11/22/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Rec'd + inspect for transit damage

0.00

11/23/10 (80)

130



QC

Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

*81012106**counts
(x80)*

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

80 10127

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=> M	10/12/07		80	0		
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M. 115951 Memo START TIME: 12:00 OVEN TEMPERATURE: 320° FINISH TIME: 12:30	0.00 0.00				80		10-12-8.	
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=> M	10/12/08		80	0		

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Identify as per dwg & Stock Location: <u>ST 476</u>	0.00							
Packaging	Memo	0.00							
Packaging									
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

ES 10/12/09 (80)

10/12/09 *[Signature]*

mf

10-12-09

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 23, 2010 9:26:12 AM

Page 1

Work Order ID: 63998



Parent Item: D2230-1



Parent Item Name: Lug

Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP ☐ D00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	298.8644	0.0683	5.751579			
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Lug Extrusion



CZ 10/11/25

Location

Loc Qty

Loc Code

MAT06

298.8644265

43722

180

45800

118.864426

5.75

D2230-1P

X80

11/23/10 (80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

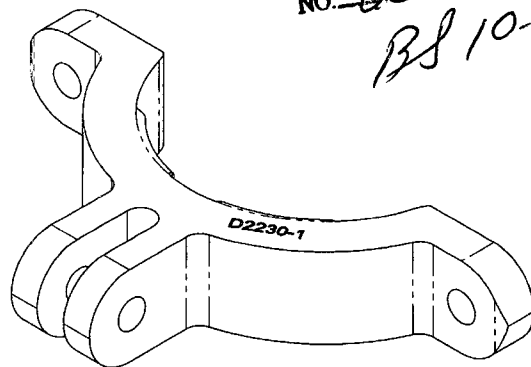
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

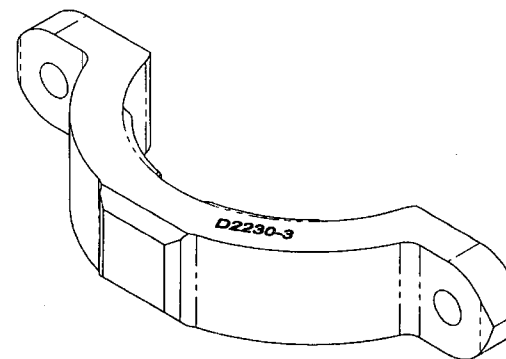
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NOTE: Date & initial all entries

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43998
BS 10-11-23



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
9/16/51



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	SA	DRAWING NO.	REV. G
MFG. APPR.	SA	D2230	SHEET 1 OF 3
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

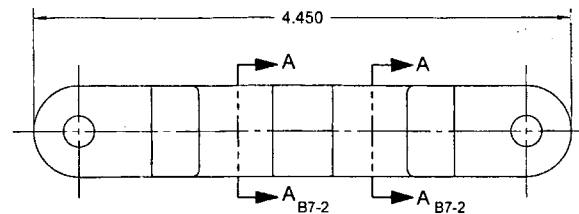
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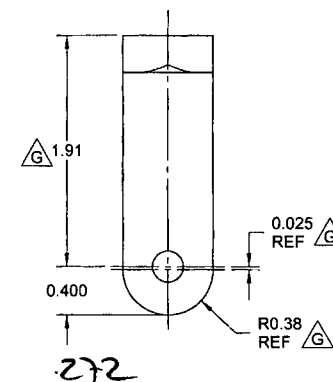
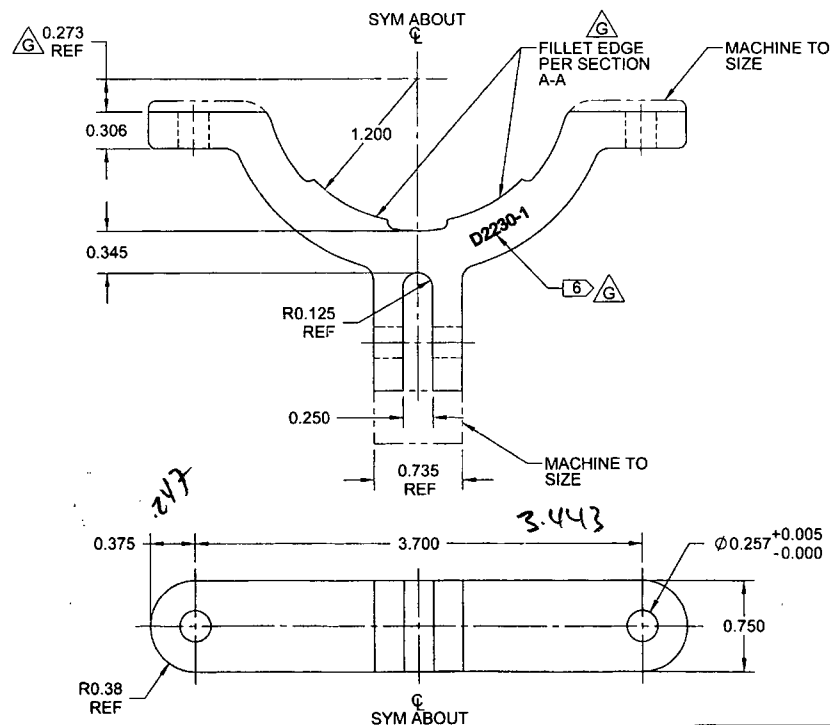
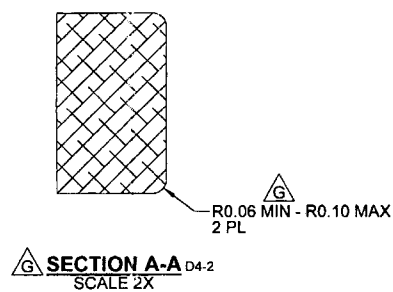
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NOTE: Date & initial all entries



W043998

60



D2230-1 MOUNTING LUG

RELEASED
09/06/15/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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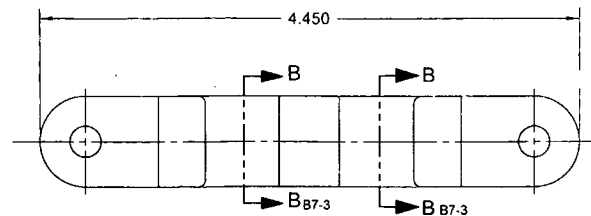
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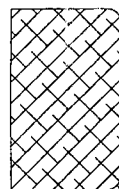
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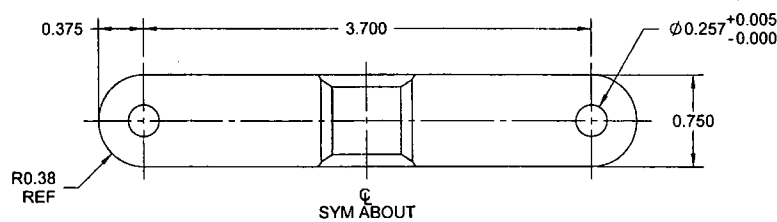
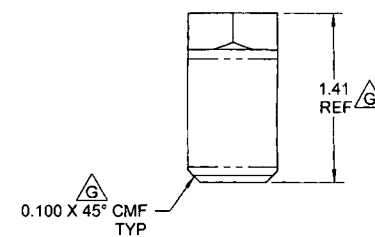
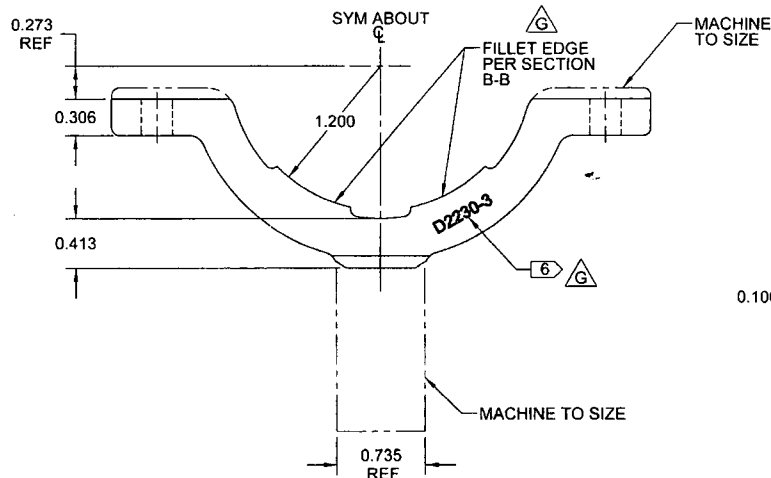
NOTE: Date & initial all entries



w/o 43998



SECTION B-B D4-3
SCALE 2X
R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/23

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13003

Purchase Order Date 11/25/10
PO Print Date 11/25/10

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
11/25/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	12/10/10 Yes	80.00 Each	Yours ppd	\$18.9500	\$1,516.00

Special Inst: MACHINE AS PER DWG D2230 REV. G
B63998

PO Total: \$1,516.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 11/25/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

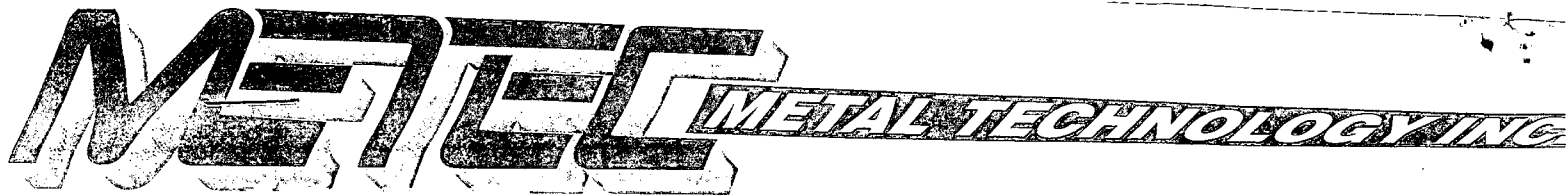


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17602
Date: Dec 02, 2010
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13003	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug	Each	80	80	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D2230-1	Mounting Lug	13000
90	D2230-1	Mounting Lug	13003

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

8/10/12/06 

Vankleek Hill, December 2, 2010